



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10

Job Sheet 171945



Part No: C10

Job Qty: 1 ea

Part Name: C-Series Remote Hook 10,000 lbs Lift Capacity



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP REV:A 17.10.23 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		2/22/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs		2/23/18	0.00	2.00	Small Fab-9		AP
120	QC	1 pcs		2/23/18	0.00	0.00	QC5		PD 15.02.14
130	DC	1 pcs		2/23/18	0.00	0.00	DC		
140	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-2		DAS 5MB
200	QC21-FG	1 Ea		2/23/18	0.00	0.00	QC21		21 FEB 15 2018

Part Op 110 - 1- PICK C10-2 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS
Descriptions: PER DWG 3- PERFORM ALL NECESSARY TEST USING FAI TEST SHEET.

130 - Photocopy blue file and create labels

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1/4-20-3/8	Set Screw	2 Ea (2 ea)	100-Start up Operation	5038424
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	110-Small Fab	5010651
188-SHCS-1032-3/4	Bolt	8 Ea (8 ea)	110-Small Fab	5041614
2595K2	Heat Shrink	1 (1 ea)	110-Small Fab	5041617
32446	Crimp Terminal	2 Ea (2 ea)	110-Small Fab	5041619
32448	16-14 AWG Knife Connector	2 (2 ea)	110-Small Fab	5041618
600.1309	CANAM Plate ID Label	1 (1 ea)	110-Small Fab	5029592
600.1347	C10 Warning Label	1 (1 ea)	110-Small Fab	5029487
AN4-23A	Bolt	2 Ea (2 ea)	110-Small Fab	F123434-40
AN6-31A	Bolt	6 Ea (6 ea)	110-Small Fab	5041084
C10-1	Side Plate Solenoid Side	1 (1 ea)	110-Small Fab	5041084
C10-10-1	Actuator Shaft	1 (1 ea)	110-Small Fab	5029189
C10-10-2	Actuator Pin	1 (1 ea)	110-Small Fab	5029190
C10-10-3	Actuator Bushing	2 (2 ea)	110-Small Fab	5029191
C10-11	Manual Release Knob	1 (1 ea)	110-Small Fab	5029192
C10-12	Solenoid Assembly (Figure 4)	1 (1 ea)	110-Small Fab	5029193
C10-12-0	Solenoid	1 (1 ea)	110-Small Fab	5029193
C10-12-1	Spring Pin	1 (1 ea)	110-Small Fab	5029434
C10-2	Side Plate - MRK	1 (1 ea)	110-Small Fab	5029194
C10-21-1	Clock Spring	2 (2 ea)	110-Small Fab	5029195
C10-21-2	Spring Cover	2 (2 ea)	110-Small Fab	5029196
C10-21-4	Lock Washer	8 Ea (8 ea)	110-Small Fab	5029197

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation S041417 C – Series Remote Hook 10,000 lbs Lift Capacity Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 – 5200 Email: sales@dartaero.com www.dartaerospace.com				sition Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																	
PART NO: C10 Original Serial #: S041417 Revision: Operation: Start up Operation 02/12/18 Change No: Job No: 171945				<table style="width:100%; border: none;"> <tr> <td style="border: none; width: 50%;"> TRY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> <td style="border: none; width: 50%;"> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>		TRY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence														
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C10-22	Lock Bumper	3 Ea (3 ea)	110-Small Fab	5029 199
C10-23	Keeper Weldment	1 (1 ea)	110-Small Fab	5029 199
C10-23-1	Keeper Spacer	1 (1 ea)	110-Small Fab	5029 200
C10-23-2	Keeper Spring	1 Ea (1 ea)	110-Small Fab	5029 200
C10-23-3	Keeper Bushing	2 (2 ea)	110-Small Fab	5029 200
C10-3	Load Beam Bumper	1 (1 ea)	110-Small Fab	5029 204
C10-4	Lock	1 (1 ea)	110-Small Fab	5029 206
C10-4-10	Spring Anchor Spring Pin	2 (2 ea)	110-Small Fab	5029 208
C10-4-11	Lock Shaft	1 (1 ea)	110-Small Fab	5029 209
C10-4-2	Lower Lock Roller	1 (1 ea)	110-Small Fab	5029 210
C10-4-3	Upper Lock Roller	1 (1 ea)	110-Small Fab	5029 212
C10-4-4	Upper Lock Roller Shaft	1 (1 ea)	110-Small Fab	5029 213
C10-4-5	Lower Lock Roller Shaft	1 (1 ea)	110-Small Fab	5029 214
C10-4-6	Lock Spring	1 (1 ea)	110-Small Fab	5029 215
C10-4-7	Spring Retaining Pin	1 (1 ea)	110-Small Fab	5029 216
C10-4-8	Lock Bushing	2 (2 ea)	110-Small Fab	5029 217
C10-4-9	Upper Roller DU Bearing	1 (1 ea)	110-Small Fab	5029 218
C10-41	Stain Relief Connector	1 Ea (1 ea)	110-Small Fab	5029 219
C10-5A	Load Beam Assembly	1 (1 ea)	110-Small Fab	5029 219
C10-7	Locating Pin	3 (3 ea)	110-Small Fab	5029 220
C10-8	Trunnion Bushing	2 (2 ea)	110-Small Fab	5029 221
C10-9-1	Latch	1 (1 ea)	110-Small Fab	5029 222
C10-9-2	Latch Bearing Torrington	1 Ea (1 ea)	110-Small Fab	5041 627
C10-9-4	Latch Shaft Bearing	2 (2 ea)	110-Small Fab	5029 223
C10-9-5	Latch Shaft	1 (1 ea)	110-Small Fab	5029 224
C10-9-6	Latch Return Spring	2 (2 ea)	110-Small Fab	5029 225
C2-14-2	Label Rivets	2 Ea (2 ea)	110-Small Fab	5029 241
C3-12-6	Lock Roller Pin Circlip	2 (2 ea)	110-Small Fab	5029 269
C45-12-6	Retaining Ring	2 (2 ea)	110-Small Fab	5029 303
C45-8-4	Solenoid Cover Gasket	1 (1 ea)	110-Small Fab	5029 330
C45-8-4	Solenoid Cover Gasket	1 (1 ea)	110-Small Fab	5029 336
C45-8-5	Solenoid Cover	1 Ea (1 ea)	110-Small Fab	5041 616
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5031 224
EL314-SJTOW	3 Wire	1 ft (1 ea)	110-Small Fab	5029 542
MS21044N6	Nut, Self-Lock .375-24, UNJF-3B	6 Ea (6 ea)	110-Small Fab	5041 083
MS21083N4	Nut	2 Ea (2 ea)	110-Small Fab	M4964
MS27039-4-08	Screw	1 Ea (1 ea)	110-Small Fab	5039 330
NAS1149F0432P	Washer	2 Ea (2 ea)	110-Small Fab	5024 448
NAS1149F0463P	Washer	3 Ea (3 ea)	110-Small Fab	FM137544-25
NAS1149F0632P	Washer	12 Ea (12 ea)	110-Small Fab	FM134497

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	188-FPSS-1/4-20-3/8	2	100	0
110-Small Fab	188-FPSS-1032-1/4	2	25	0
	188-SHCS-1032-3/4	8	0	0
	2595K2	1	0	0
	32446	2	0	0
	32448	2	0	0
	600.1309	1	0	0
	600.1347	1	0	0
	AN4-23A	2	632	0
	AN6-31A	6	0	0
	C10-1	1	0	0
	C10-10-1	1	0	0
	C10-10-2	1	0	0
	C10-10-3	2	0	0
	C10-11	1	0	0
	C10-12	1	0	0
	C10-12-0	1	0	0
	C10-12-1	1	0	0
	C10-2	1	0	0
	C10-21-1	2	0	0
	C10-21-2	2	0	0
	C10-21-4	8	100	0

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

C10-22	3	0	0
C10-23	1	0	0
C10-23-1	1	0	0
C10-23-2	1	0	0
C10-23-3	2	0	0
C10-3	1	0	0
C10-4	1	0	0
C10-4-10	2	0	0
C10-4-11	1	0	0
C10-4-2	1	0	0
C10-4-3	1	0	0
C10-4-4	1	0	0
C10-4-5	1	0	0
C10-4-6	1	0	0
C10-4-7	1	0	0
C10-4-8	2	0	0
C10-4-9	1	0	0
C10-41	1	20	0
C10-5A	1	0	0
C10-7	3	0	0
C10-8	2	0	0
C10-9-1	1	0	0
C10-9-2	1	11	0
C10-9-4	2	0	0
C10-9-5	1	0	0
C10-9-6	2	0	0
C2-14-2	2	200	0
C3-12-6	2	0	0
C45-12-6	2	0	0
C45-8-4	2	0	0
C45-8-5	1	0	0
EL-PLUG-M	1	38	0
EL314-SJTOW	1	250	0
MS21044N6	6	0	0
MS21083N4	2	0	0
MS27039-4-08	1	100	0
NAS1149F0432P	2	1,586	0
NAS1149F0463P	3	158	0
NAS1149F0632P	12	60	0

Part Specifications

Specifications could not be found.

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Root Cause		FAULT CATEGORY			
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OTHER : _____					



Remote Cargo Hook Test Form

C10

Work Order

171945

Customer

Serial Number

S041417

Date

2018/02/13

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/fail
1	25,000	Static Hold	Hold for two Minutes and reduce load to zero	N/A	PASS
10	5,000	Electircal, 25 volts	No "hang ups" permitted	N/A	PASS
2	10,000	Electircal, 22 volts	Current shall not exceed 12.4A	9.7 Amp.	PASS
2	7,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.6 Amp.	PASS
2	5,000	Electircal, 22 volts	Current shall not exceed 12.4A	9.5 Amp.	PASS
2	2,500	Electircal, 22 volts	Current shall not exceed 12.4A	9.5 Amp.	PASS
2	500	Electircal, 22 volts	Current shall not exceed 12.4A	9.4 Amp.	PASS
1	10,000	Electircal, 20 volts	Current shall not exceed 11.3A	8.0 Amp.	PASS
1	10,000	Electircal, 28 volts	Current shall not exceed 15.8A	12.0 Amp.	PASS
1	10,000	Manual		N/A	PASS
1	10,000	Impact Test	Impact shackle 10 times, shall not release	N/A	PASS
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ohms	2.0 Ohms	PASS
1	N/A	Electircal Continuity	Across both wires	N/A	PASS

Test Conducted By

ALAIN PATRY

Technician

Signature:

Director of Quality Assurance

Submit